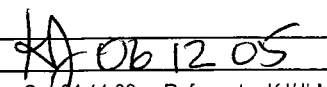
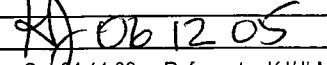


Date: Tuesday, 12/5/2006 8:01:49 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SHORT STEP INSTALLATION KIT	
Job Number :	29747			
Estimate Number :	10542			
P.O. Number :		Part Number :	K591113	
This Issue :	12/5/2006	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D350-591 REV F PG17	
First Issue :	/ /	Project Number :	N/A	
Previous Run :	28535	Drawing Revision :	F	
	Type :	Material :		
	SMALL /MED FAB	Due Date :	1/10/2007	Qty: 10 Um: Each
Written By :				
Checked & Approved By :				
Comment :	Est: C 04.11.09 Reformat KJ/JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D2171	Clamp
-----	-------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Clamp

Pick:

Qty	Part Number	Description
2	D2171	Clamp

Batch

B29083 -

2.0	D2182B	Neoprene Cushion-.750 bl
-----	--------	--------------------------



Comment: Qty.: 0.5833 f(s)/Unit Total : 5.8330 f(s)

Neoprene Cushion-.750 bl

Pick:

Qty	Part Number	Description
7"	D2182B	Cushion

Batch

B28042 -

3.0	D2274	Radius Block
-----	-------	--------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Radius Block

Pick:

Qty	Part Number	Description
4	D2274	Radius Block

Batch

B28713 -

4.0	D23623	Step Support Bracket
-----	--------	----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Step Support Bracket

Pick:

Qty	Part Number	Description
1	D2362-3	Support Bracket

Batch

B29436 8x

B29775 2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:01:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP INSTALLATION KIT

Job Number: 29747

Part Number: K591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 6.0000 f(s)

Abrasion Strip

Pick:

Qty Part Number Description Batch

7.2" (QTY 1) D2856-400 Abrasion Strip

328258 ✓

6.0

AN337A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

2 AN3-37A Bolt

M14978 ✓

7.0

AN420A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

4 AN4-20A Bolt

M16895- ✓

8.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch

1 AN4-22A Bolt

M17280 2P M10771 8X ✓

9.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

4 AN960JD10 Washer

M6140 18X ✓

M100743 22X ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:01:49 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT STEP INSTALLATION KIT

Job Number: 29747

Part Number: K591113

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

AN960JD416

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
6	AN960JD416	Washer	M1000524X

Batch

M102339 36X

11.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	MS21042L3	Nut	M101919

Batch

M101919

12.0

MS21042L4

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 50.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
5	MS21042L4	Nut	M9963 48X

Batch

M19188 2X - 12/4/21

13.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

C20710111

(10)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

C20710111

Job Completion



U 07.01.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	<i>Heli-Access-Step</i> ™, Long Step – High Skid
	X					D350-591-113	<i>Heli-Access-Step</i> ™, Short Step – High Skid
		X				D350-591-115	<i>Heli-Access-Step</i> ™, Short Step – Low Skid
			X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
				X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
					X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
8	4	4	4	4		AN4-20A	BOLT
1	1	1		1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	6	4	6	14	AN960JD416	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

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Date: 04.03.02